

538

SPLIT

DART AEROSPACE LTD	Work Order:	23989 A
Description: Clevis	Part Number:	D3447-5
Dwg: D3447 Rev. A page 2	Qty:	20 5
Replaces Premier P/N B67-43001-99		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JP	05/08/30	20
2	MC	Turn as per Folio & Dwg B67-43001 Dwg Rev: _____ Material: 6061-T6 Bar Ø1.00 (QQ-A-200/8 or QQ-A-225/8) (M6061T6R1.000) M17887 Identify for D3447-5 Batch: M18147	J.G	05/09/07	20
3	QC2	Inspect parts as they come off the machine Identify as D3447-5	J.G	05/09/07	20
4	MM	Mill as per Dwg D3447	JP	05/09/19	20
5	QC2	Inspect parts as they come off the machine	TS	05-09-20	20
6	QC8	Second check	J.G	05/09/20	20
7	MM	Deburr	TS	05-09-20	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1	FC	05 09 26	20
9	FP	Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3 Mask 0.875" round section	M	05 09 28	20
10	QC3	Inspect Powder Coat	CL	05/09/29	5
11	ST	Identify and Stock	CL	05/09/29	5
12	AC	Cost / part: 17.89	S4C	05-10-04	5
13	DC	Close W/O 17.49 Inspect Level 21	JP	05/10/14	5

Rev	Date	Change	Revised By	Approved
A	05.08.26	New issue	KJ/JLM	

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 05/10/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



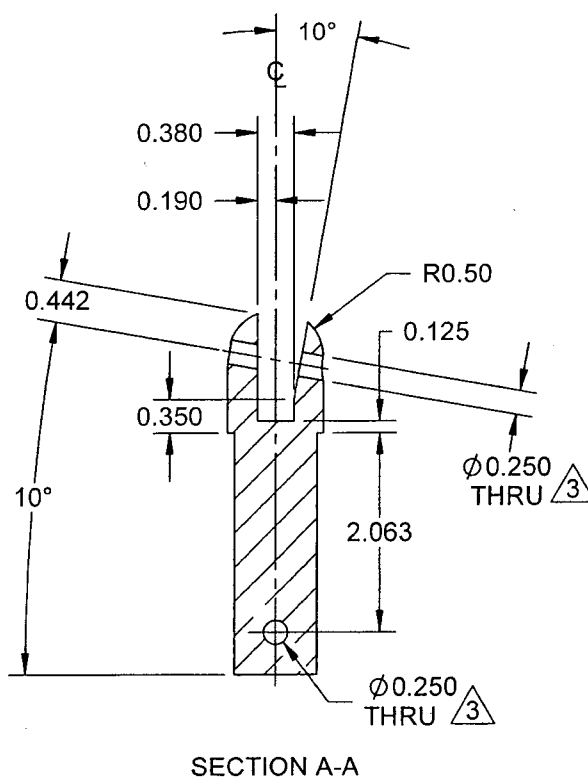
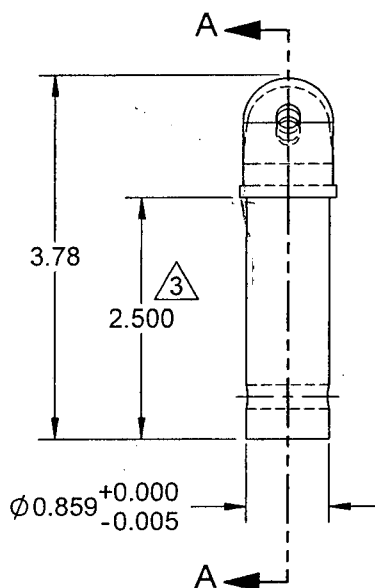
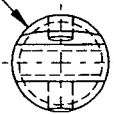
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 2 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE.

WORK ORDER
NO. 23989

Ø1.00
(REF)



D3447-5 CLEVIS

SUPERSEDES PREMIER P/N B67-43001-99

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 30, 2005
10:04 am

Work Order No : 0023989
Project Name : D3447-5
Project For : WK538
Work Order Type : Main
Main WO Number :
House Part Number : D3447-5
Description : Clevis
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 08-09-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.40	100.00		
Production Cost :	0.00	6.79	100.00	0.00	6.79
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	6.79	100.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	6.79			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-6.79)

